

Work Order ID 50253

July 14, 2009 10:43:25 AM



Page 1

Item ID: D3183-042

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 5.00



Customer:

Reference:

7/14/09-07/16

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo	0.00	6	PTO Last Page
D3183	Rev C1				
100		BAND SAW	0.00		
Bandsaw			0.00		
Jeaspa Bandsaw		Cut blanks: (1.500" x 2.000") 4.300" long		mmf 09/08/11	

110	HAAS CNC VERTICAL MACHINING #1	0.00		
HAAS 1		0.00		
HAAS CNC vertical machine #1		1-Machine D3183-2 as per Folio FA320 and Dwg D3183-1 Identify as D3183-2 2-Deburr 3-Scribe batch number		
			mmf 09/08/11 / SL 09/08/13	

120	QC2- Inspect parts off machine FAI/FAIB	0.00	
QC		0.00	
Quality Control			mmf 09/08/12 / SL 09/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183-042 PAR #: Wp Fault Category: Mature NCR: Yes No DQA: 1 Date: 09-08-26
 Scrap 1 Scrap QA: N/C Closed: ✓ Date: 09-08-27

NCR: 50253		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/19	110	One part pop out of the Jig on first operation R.C. feed too fast when	<u>OSLMR</u>	Scrap no replace cont remachine the part w/ the Jig. Qty (1)	<u>88</u> 09/08/19	<u>88</u> 09/08/19	<u>OSLMR</u>	<u>09-08-19</u>
		machine back angle R.C. program	<u>OSLMR</u>	re-adjust feed in program,	<u>J.F.S</u> 09/08/19	<u>J.F.S</u> 09/08/19	<u>OSLMR</u>	<u>09-08-19</u>

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

JP09/08/19

140



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Assemble D3183-041 as per Dwg D3183.

JP09/08/20 5

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

=> S 09/08/20

(15)

✓

nt

10:43:24 AM

Page 1

Order ID: 50253



Parent Item: D3183-042RevC1



Parent Item Name: Bracket Assembly

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-21RevE		Manufactured	No			140	Each	74.0000	10.0000		Ep09/08/20	

Bolt

Warehouse

Location

Main Warehouse

ST	74
46032	17
46739	17
50096	40

D3183-045RevC1



Manufactured

No

100 Each 19.0000 10.0000



Bearing Assembly

Warehouse

Location

Main Warehouse

ST	19
46393	3
47756	16

M174B2.000X01.500



Purchased

No

140 f 2.9600 2.4121



17-4 SS Bar 2.00 x 1.500

Warehouse

Location

Main Warehouse

MAT	2.96
14773	1.29
19478	1.67

17-4 SS Bar 2.25 x 1.500 11899

mm
2.25 x 1.500

2.2575

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/08/13	110	- 2 parts scrapped, popped out of jig and parts were damaged by end-mill	Initial Chief Eng	Scrap & replace Qty 2 M 11/8/13	JL 09/08/13	mm 2 09/08/14	W.S. M 09/08/14	W.S. M 09/08/14
		while flying out R.C. process	Initial Chief Eng					
			Initial Chief Eng					

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50253
Description: Bracket		Part Number:	D3183-2
Inspection Dwg: D3183 Rev: C1			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

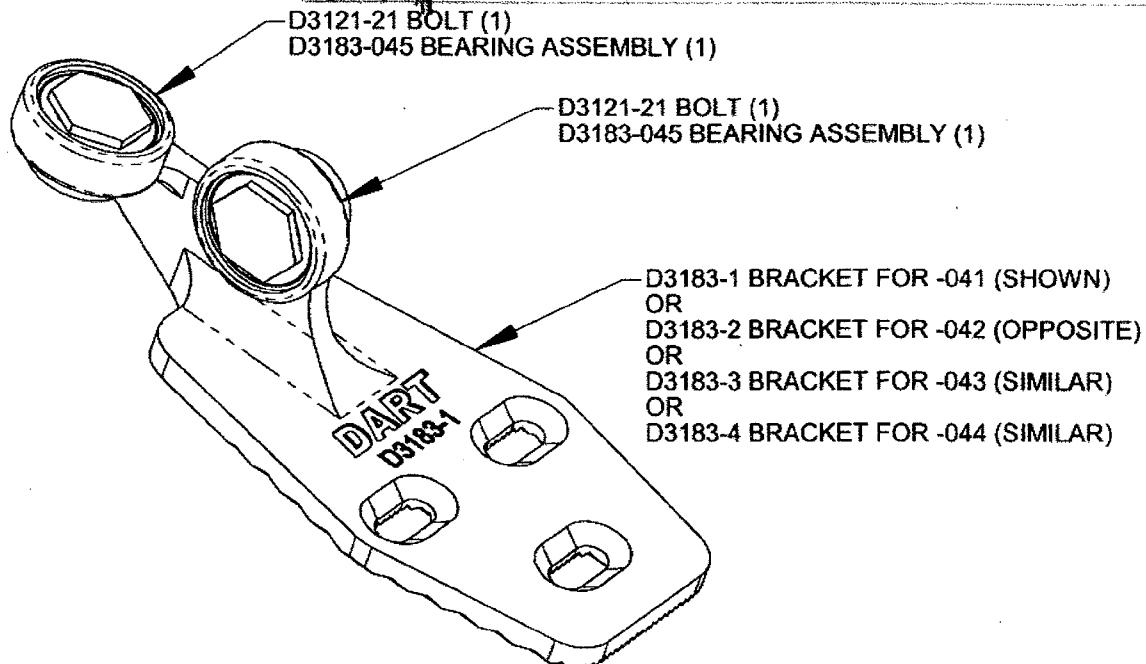
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.162	+/-0.010	1.68				
R0.25	+/-0.030	0.250				
3.105	+/-0.010	3.106				
2.075	+/-0.010	2.075				
0.786	+/-0.010	0.77				
0.162	+/-0.010	0.163				
100°	+/-0.05°	100°				
2.799	+/-0.010	2.800				
Ø0.392	+0.002/-0.000	0.393				
1.90	+/-0.030	1.889				
0.218	+/-0.010	0.212				
0.500	+/-0.010	0.500				
3.881	+/-0.010	3.886				
4.17	+/-0.030	4.17				
Ø0.201 x 100 deep	+/-0.010	0.199 x 101				
0.182	+/-0.010	0.182				
0.070	+/-0.010	0.070				
0.100	+/-0.010	0.104				
4.8°	+/-0.05°	4.8°				
0.381	+/-0.010	0.391				
0.200	+/-0.010	0.200				
0.435	+/-0.010	0.433				
0.615	+/-0.010	0.613				
0.032	+/-0.010	0.030				

Measured by:	MWP	Audited by:	Arn	Prototype Approval:	N/A
Date:	09/08/20	Date:	09/08/20	Date:	N/A

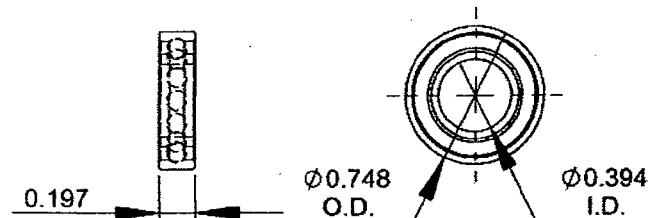
Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue (P/O D3183-042)	KJ/JLM	JL

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE	04.02.17	TITLE	SCALE 1:1

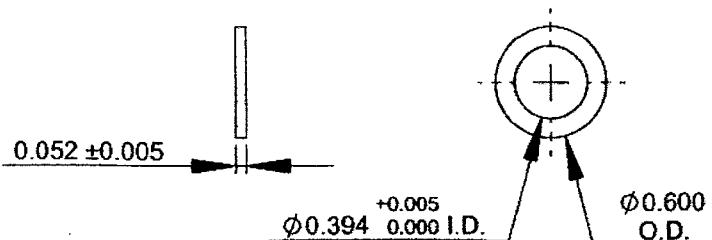
RELEASED
04.03.01

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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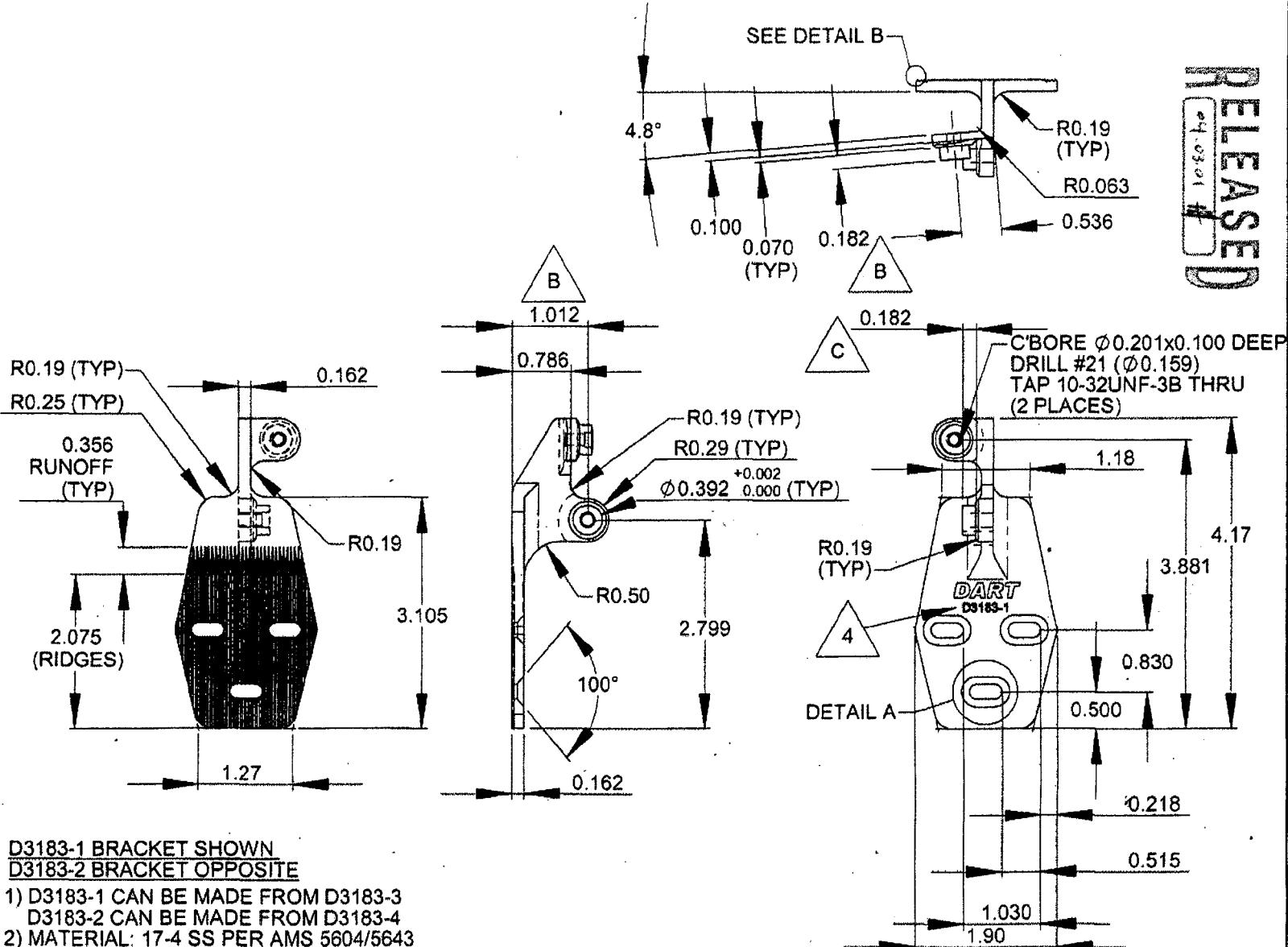
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ACCURATE
PRINTED

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		D3183
DATE	04.02.17	REV. C
		SHEET 2 OF 4
		SCALE 1:2

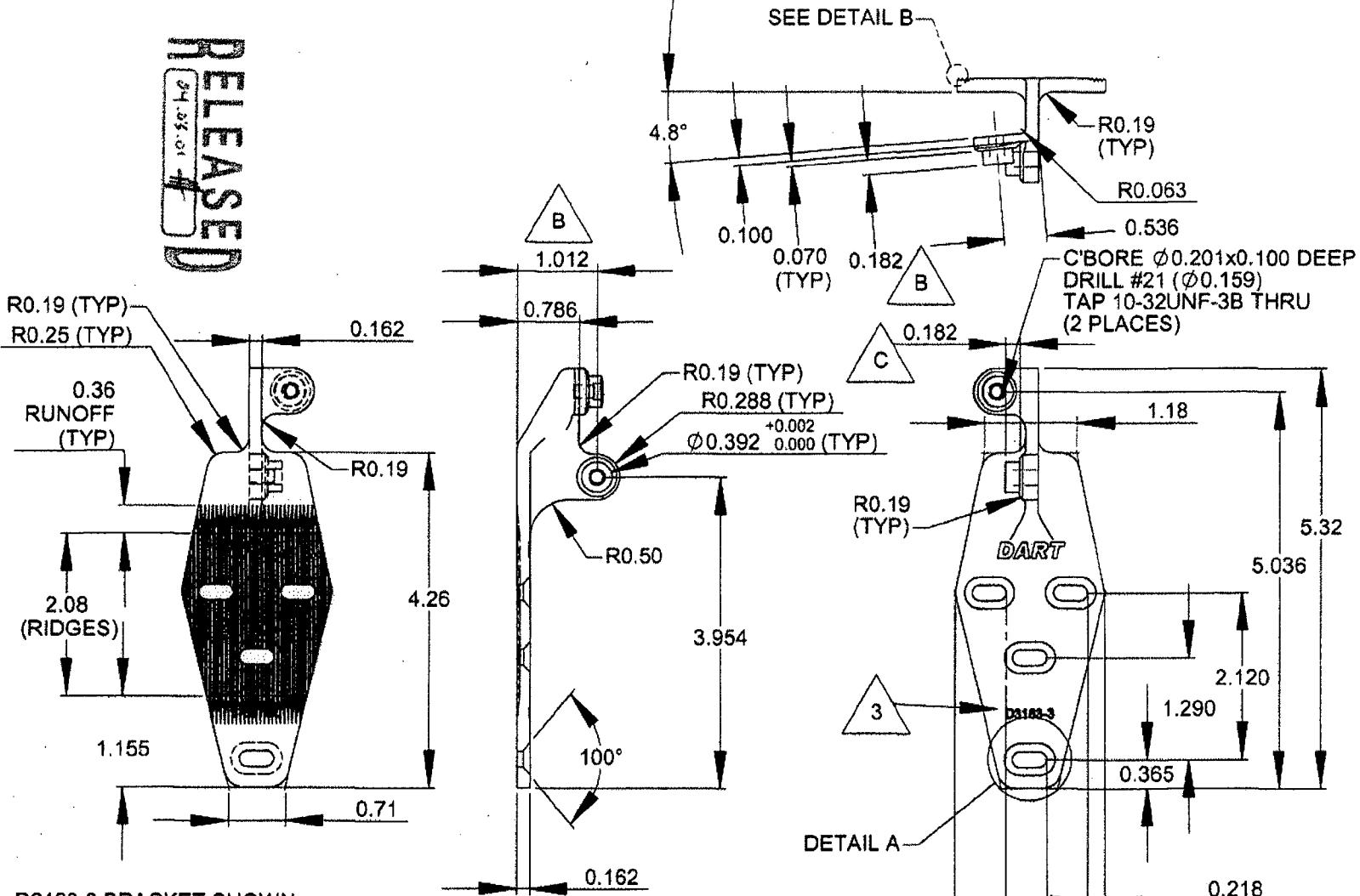
RELEASED
04.03.01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

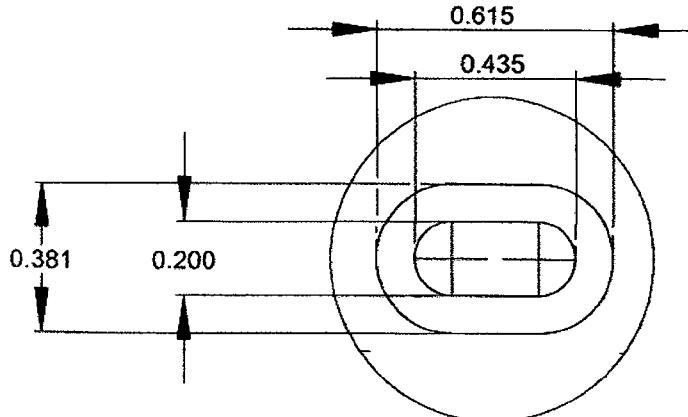
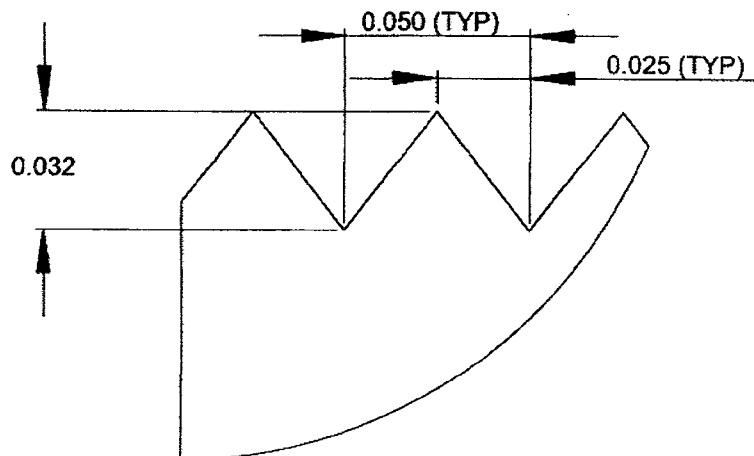
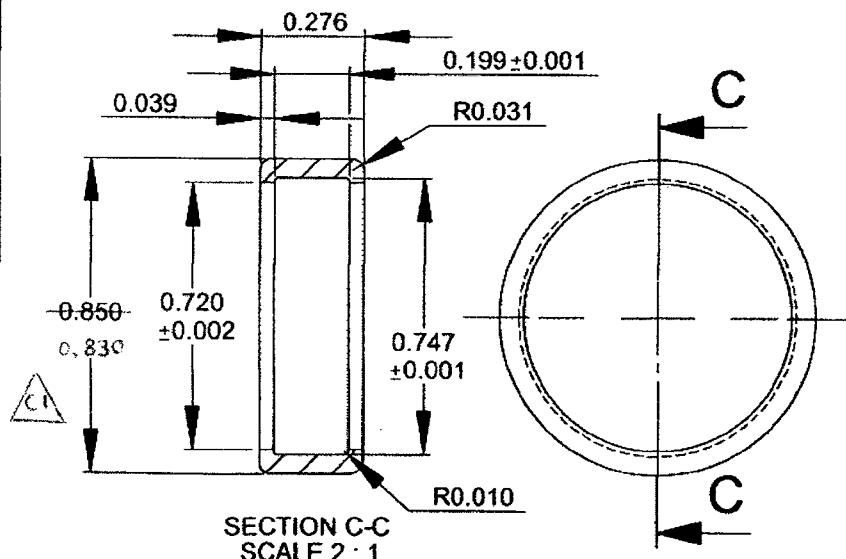
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34-33-01



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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO.
		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 3 OF 4
SCALE	1:2	REV. C

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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE 1:1 BRACKET ASSEMBLY

DETAIL A (2 : 1)**RELEASED**
04-03-01C
S205DETAIL B (20 : 1)**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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